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D4149-5
Job Sheet 170798



Part No: D4149-5

Job Qty: 8 ea

Part Name: Eyebolt Stud



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/19/18

Job Tracking No:

Due Date: 2/26/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 10-07-22 JLM VERIFIED BY:DD IPP Rev:B 11.03.03 as per revC DD
verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea			0.00	0.00	Start Up Machining-2		<i>MIP 18/02/13</i>
100	Doosan	8 pcs			0.33	2.14	Doosan		<i>MIP 18/02/13</i>
120	QC	8 pcs			0.00	0.00	QC8		<i>STK 18/02/14</i>
150	Packaging	8 pcs			0.00	0.00	Packaging3-2		<i>EP 51086</i>
160	QC21-SA	8 Ea			0.00	0.00	QC21		<i>DAS 21 9-80</i>
Part Op Descriptions: 100 - turn as per dwg and folio FA950									FEB 14 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R1.000	303 Round Bar 1.00	2 ft (.25 ea)	90-Start up Operation	

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Eyebolt Stud	0.250Inches + 0.003 - 0.000	0.253 0.250	Diameter	<i>0.250</i>
2	Eyebolt Stud	1.380Inches ± 0.030	1.410 1.350		<i>1.380</i>
3	Eyebolt Stud	0.400Inches + 0.000 - 0.010	0.400 0.390		<i>0.395</i>
4	Eyebolt Stud	0.700Inches + 0.010 - 0.000	0.710 0.700		<i>0.707</i>
5	Eyebolt Stud	0.030Inches ± 0.010	0.040 0.020	Radius	<i>0.030</i>
6	Eyebolt Stud	0.375Inches + 0.000 - 0.020	0.375 0.355	Diameter	<i>0.365</i>
7	Eyebolt Stud	0.700Inches + 0.000 - 0.010	0.700 0.690	Diameter	<i>0.695</i>
8	Eyebolt Stud	0.200Inches ± 0.010	0.210 0.190		<i>0.200</i>
9	Eyebolt Stud	1.500Inches ± 0.010	1.510 1.490		<i>1.501</i>
10	Eyebolt Stud	0.060Inches ± 0.030	0.090	Radius	<i>0.060</i>

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			

				0.030
11	Eyebolt Stud	2.880	2.880Inches ± 0.030	2.910 2.850
12	Eyebolt Stud	0.313	0.310Inches ± 0.010	0.320 0.300
13	Eyebolt Stud	0.751	0.750Inches + 0.003 - 0.000	0.753 0.750
14	Eyebolt Stud	0.746	0.750Inches ± 0.030	0.780 0.720
15	Eyebolt Stud	0.740	0.735Inches ± 0.010	0.745 0.725

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / U

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐
Part No. _____		
NCR No. _____		

Date : _____ Step #: _____ QTY Effective : _____

Description Work Order Deviation

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Root Cause				FAI			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/L ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐				
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐						
OTHER : _____							

PART NO: D4149-5
Original Serial #: S041971
Revision:
Operation:
Change No:

Start up Operation 02/13/18

Job No: 170798

Eyebolt Stud



DART
AEROSPACE
S041971

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☐ Out of Sequence	☐ Part Moved
☐ Off-set	☐ Drawing
☐ Mislabeled	☐ Finish
☐ Fit/Function	☐ Misread
☐ Misaligned/off center	☐ Turning Sequence